

Date: Friday, 11/05/2007 1:11:30 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT ASSEMBLY
Job Number : 32328	
Estimate Number : 10808	
P.O. Number : N/A	Part Number : D3180041
This Issue : 11/05/2007 S.O. No. : N/A	Drawing Number : D3180 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 24884	Material : N/A
Written By : _____	Due Date : 18/05/2007 Qty: 2 Um: Each
Checked & Approved By : _____	
Comment : Est Rev: A 03.01.27 New issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 3.7625 f(s)/Unit Total : 7.5249 f(s)
 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall
 (M304TR0.750W0.049) *065* *07-05-14*
 Batch: *1104425*

2.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Punch 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall to length as per Dwg D3180 using DT8313
 Ensure rotate and punch one end only as per view B-B as per Dwg. D3180

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.203" as per Dwg D3180
 2-Bend one side only as per Dwg D3180 Identify as D3180-1
 3-Deburr edges

065 *07-05-14* *2*

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SB *07/05/14* *2*

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Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2022-101 Spacer B26064

8.0

D26906

Lanyard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2690-6 Lanyard B28519

9.0

A1449

Grommet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3180-1(ref) Strut B32328

1 A1449 Grommet M1487

10.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN960JD10 Washer M103947

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	BLRS001	Pip Pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 BLRS-001 Pip Pin M15608

12.0	MS21042L3	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) M104215

13.0	MS27039110	Screw
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-10 Screw M18836

14.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3180

07-05-14 (2)

15.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SB 07/20/14 (20)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT ASSEMBLY

Job Number: 32328

Part Number: D3180041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

IB 07-05-14 (2)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2) 07-05-14

Job Completion

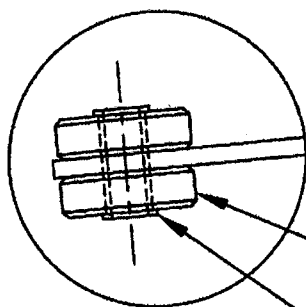
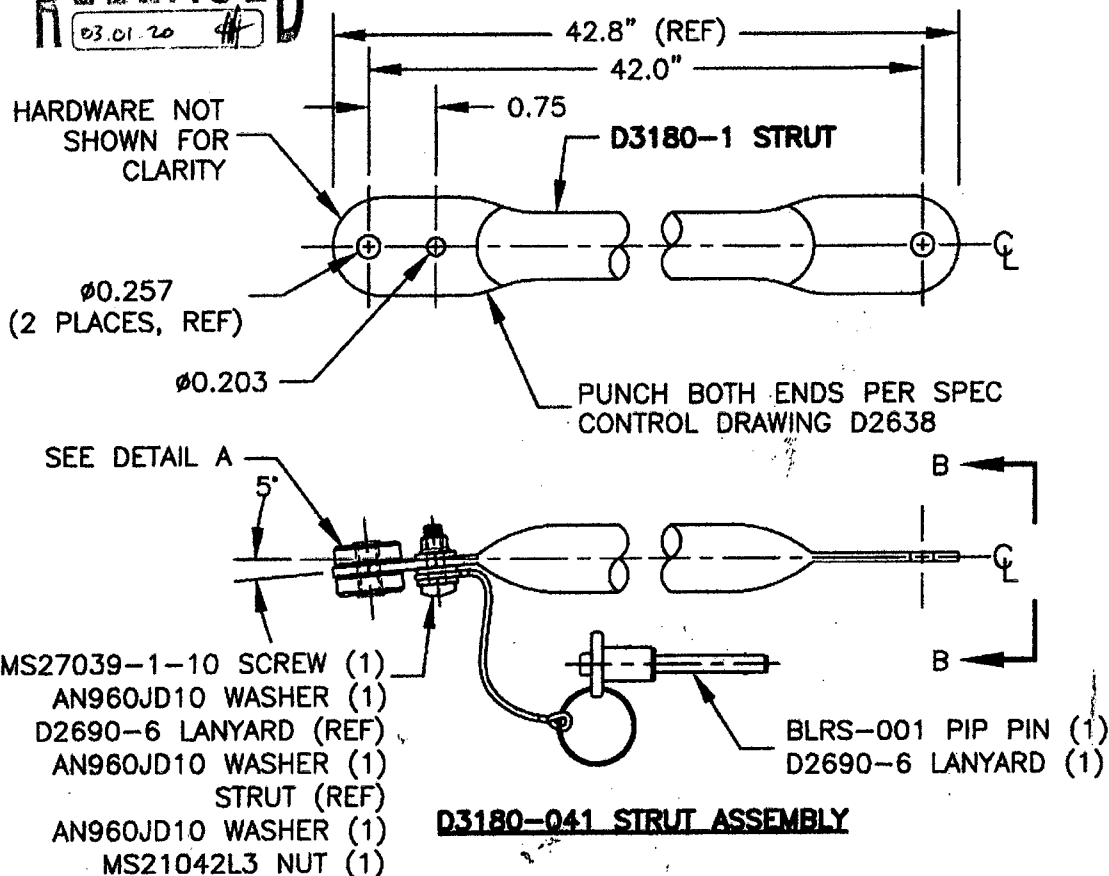


07-05-14

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3180	REV. A SHEET 1 OF 1
DATE 03.01.06	TITLE STRUT ASSEMBLY		SCALE 1:1
A	03.01.06	NEW ISSUE	

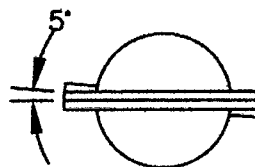
RELEASED
03.01.20 *[Signature]*



DETAIL A
SCALE 1:1

D2022-101 SPACER
(2 PLACES)

SWAGE D2022-101 SPACERS ONTO
D3180-1 STRUT USING A1449 GROMMET
(1 PLACE)



VIEW B-B
SCALE 1:1

D3180-1 STRUT

- 1) MATERIAL: AISI 304/316/318 SS TUBE, $\phi 0.75 \times 0.049$ WALL
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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